

Date: Wednesday, 9/13/2006 4:32:47 PM
 User: Kim Johnston

Process Sheet

SPHIT-2

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28538 -2
 Estimate Number : 12186
 P.O. Number : N/A
 This Issue : 9/13/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : 26954
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A New Issue 06-02-03 JLM

Drawing Name : SHUT-OFF VALVE ASSEMBLY
 Part Number : D3469041
 Drawing Number : D3469 REV A1
 Project Number : N/A
 Drawing Revision : A1
 Material : N/A
 Due Date : 10/6/2006 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D3469043 TUBE ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|---------------|---------|
| 1 | D3469-043 | Tube Assembly | B 28556 |

2.0 D3470041 SHUT-OFF VALVE SHAFT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------------------|---------|
| 1 | D3470-041 | Shut-Off Valve Assembly | B 28557 |

3.0 D34705 PLATE VALVE



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------------|
| 4 | D3470-5 | Plate Valve | B 26116 (12mx) |

4.0 D34707 valve seal



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------------------------------|
| 2 | D3470-7 | Valve Seal | B 26988 - 3mx B 28558 - 4mx |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 9/13/2006 4:32:47 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE ASSEMBLY

Job Number: 28538

Part Number: D3469041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34709

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch:

B 24384

B 26387 - 3mx

6.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN310-4

Nut

M19096

m19096(3mx)

7.0

AN9604L

washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960-4L

Washer

M14606

m 101389 (12mx)

8.0

AN960416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960-416

Washer

M5519

m5519 (12mx)

9.0

MS24665153

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

COTTER PIN

Batch:

m19096

m19096 (3mx)

10.0

MS35206217

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS35206-217

Screw

m13883

m13883 (12mx)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/11/17

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 9/13/2006 4:32:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE ASSEMBLY

Job Number: 28538

Part Number: D3469041

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

NAS679A04

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 NAS679-A04 Nut m100551

m100546 (12mx)
m100551 (4mx)

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3469

mf. 06-11-09 (3)
mf. 06/10/17 (1)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure Unit Opens and Closes Smoothly

SB 06/11/15 (3)
SB 06-10-17 (1)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1 ST358

Identify with a permanent fine point marker and Stock

Location: ST 6A

06/11/16 (3)
SB 06/10/17 (1)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/17 (4)

Job Completion



06.11.17

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

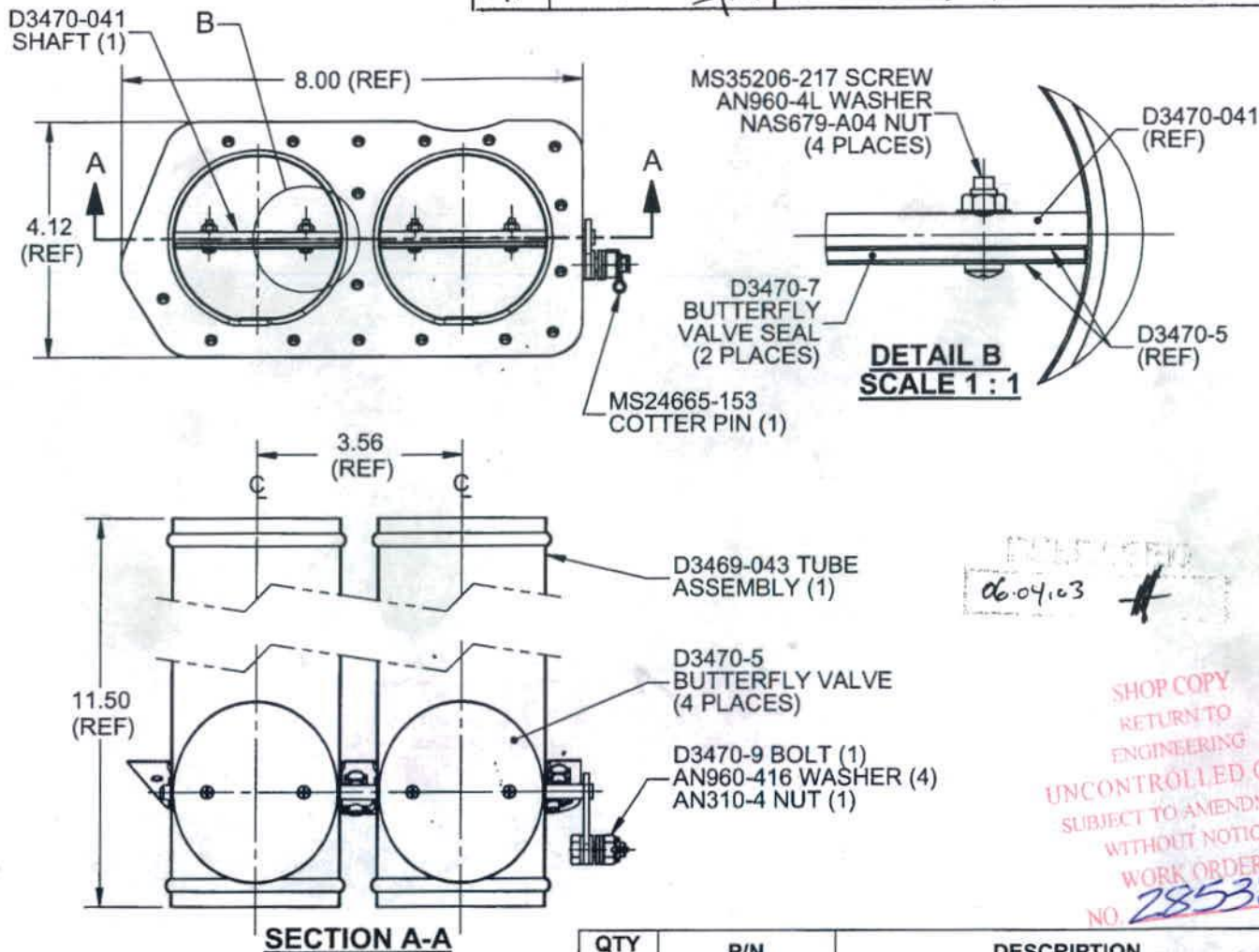
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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| DESIGN B | DRAWN BY B | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED H | DRAWING NO. D3469 | REV. A SHEET 1 OF 5 |
| DATE 05.12.12 | | TITLE SHUT-OFF VALVE ASS'Y | SCALE 1:3 |
| A | 05.12.12 | NEW ISSUE | |
| A1 | 06.04.20 | CORRECTED BOM ON PAGE 2 | |

**D3469-041 SHUT-OFF VALVE ASS'Y****NOTES:**

- 1) IDENTIFY WITH DART P/N D3469-041 USING FINE POINT PERMANENT INK MARKER
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

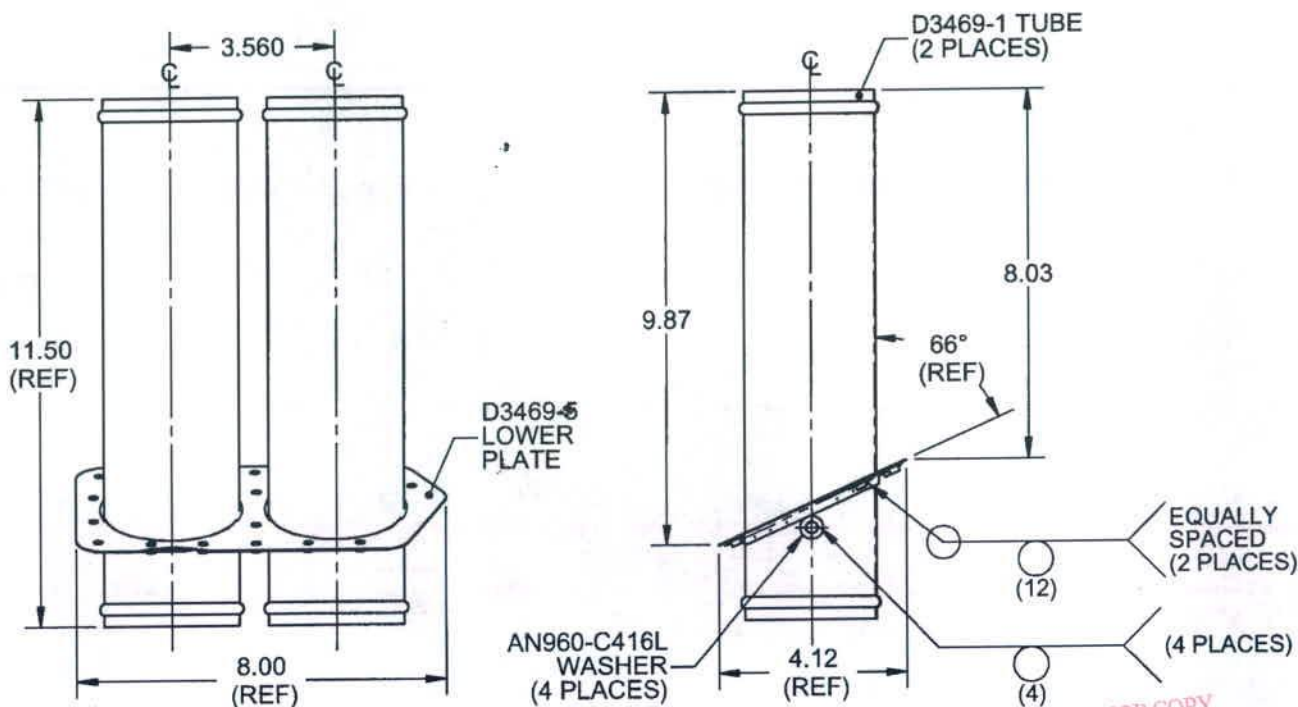
| QTY -041 | P/N | DESCRIPTION |
|-------------|-------------|-------------------------|
| X | D3469-041 | SHUT-OFF VALVE ASSEMBLY |
| 1 | D3469-043 | TUBE ASSEMBLY |
| 1 | D3470-041 | SHUT-OFF VALVE SHAFT |
| 4 | D3470-5 | BUTTERFLY VALVE |
| 2 | D3470-7 | BUTTERFLY VALVE SEAL |
| 1 | D3470-9 | BOLT |
| 1 | AN310-4 | NUT |
| 4 | AN960-4L | WASHER |
| 4 | AN960-416 | WASHER |
| 1 | MS24665-153 | COTTER PIN |
| 4 | MS35206-217 | SCREW |
| 4 | NAS679-A04 | NUT |

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| CHECKED # | APPROVED # | DRAWING NO. D3469 | REV. A SHEET 2 OF 5 |
| DATE 05.12.12 | | TITLE SHUT-OFF VALVE ASS'Y | SCALE 1:4 |



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NO. **28538**

D3469-043 TUBE ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

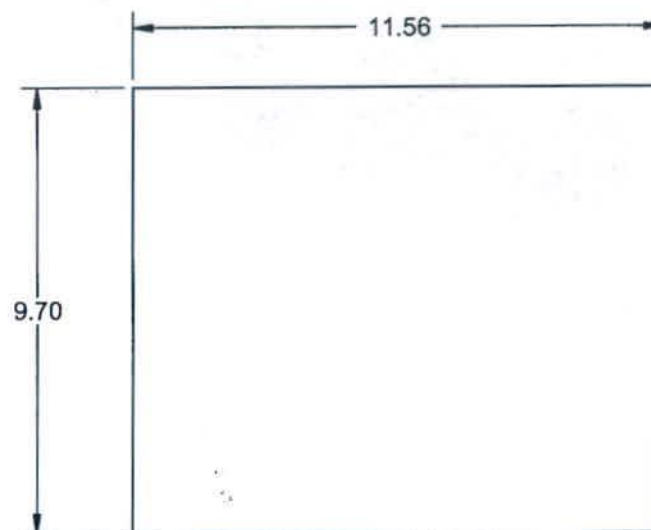
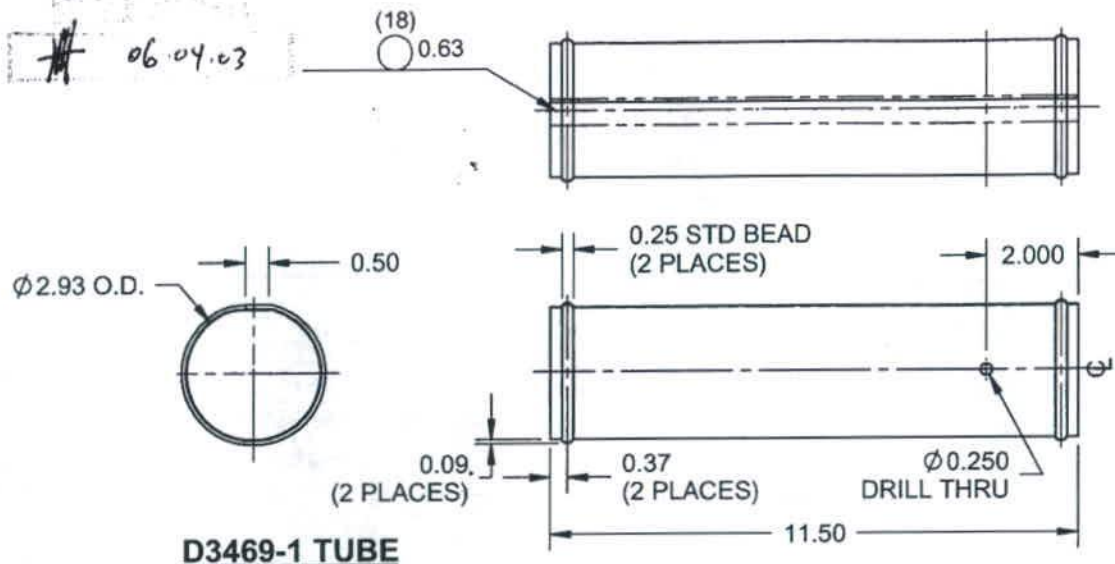
| QTY -043 | P/N | DESCRIPTION |
|--------------|--------------------|------------------------|
| X | D3469-043 | TUBE ASSEMBLY |
| 2 | D3469-1 | TUBE |
| 1 | D3469-5 | LOWER PLATE |
| 4 | D3470-5 | PLATE VALVE |
| 4 | AN960-C416L | WASHER |

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| DATE 05.12.12 | TITLE SHUT-OFF VALVE ASS'Y | | SCALE 1:4 |

**D3469-1F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

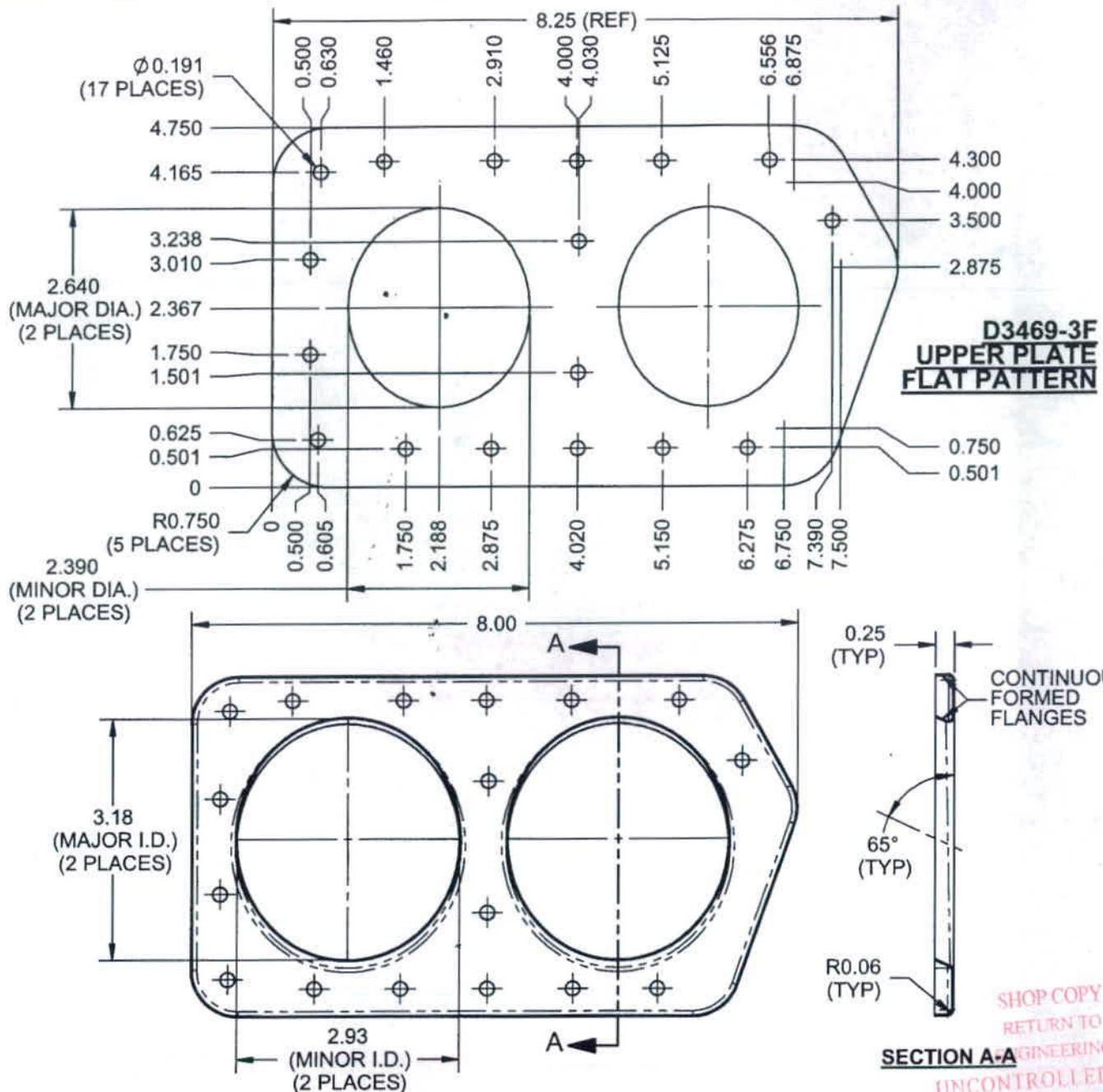
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| DATE 05.12.12 | TITLE SHUT-OFF VALVE ASS'Y | | SCALE 1:2 |



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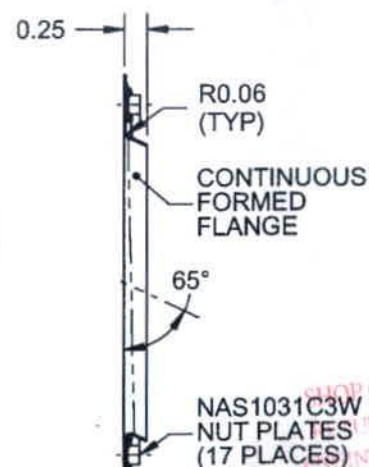
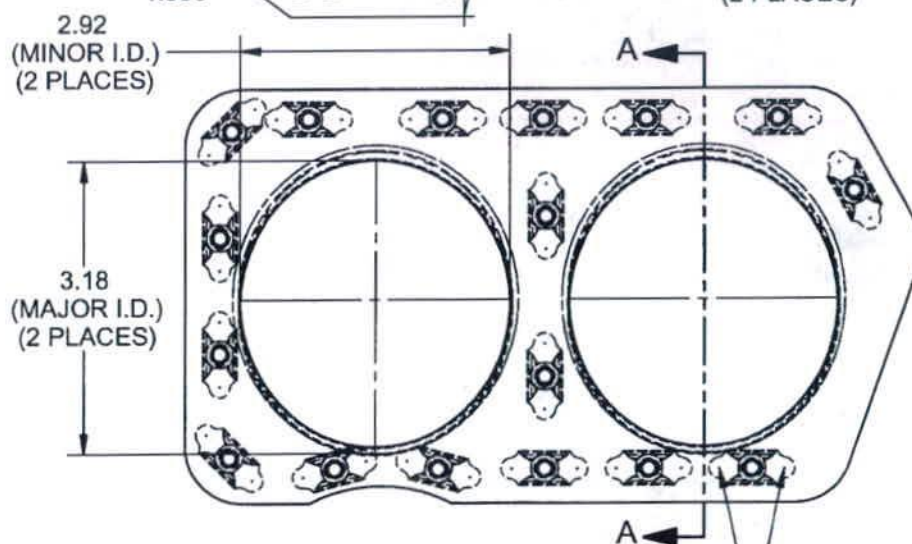
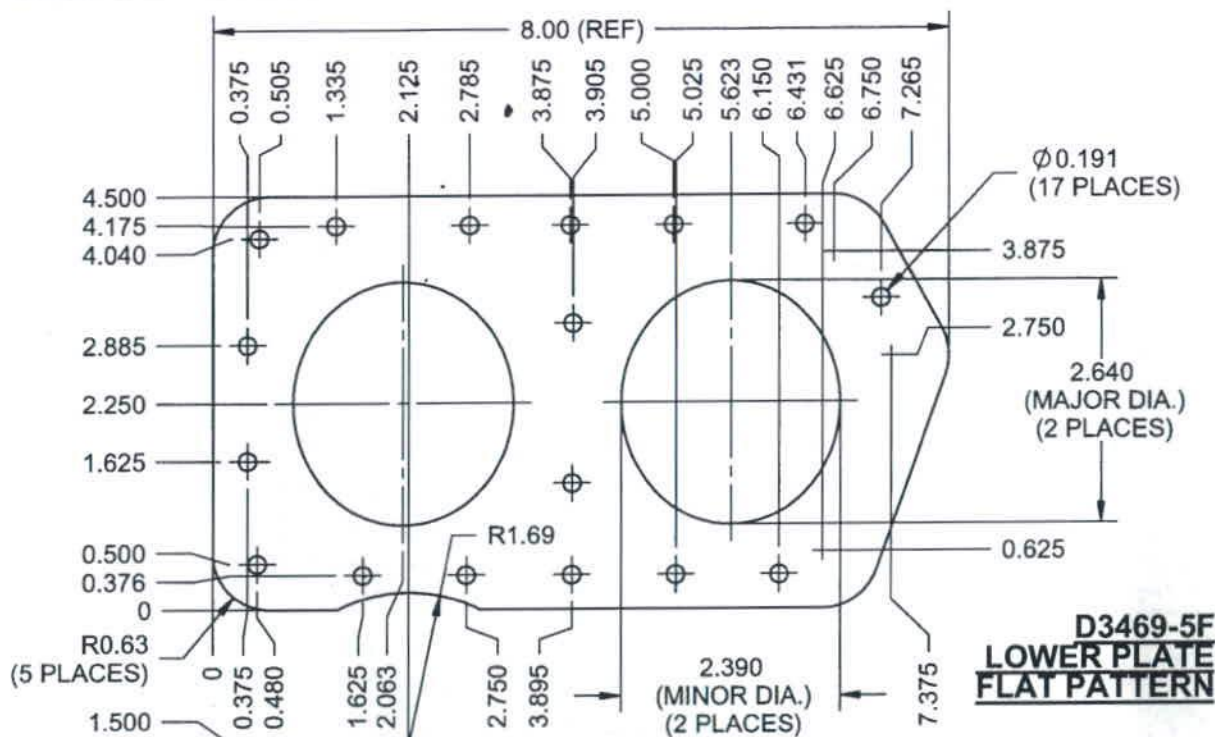
06.07.03

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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3469 | REV. A SHEET 5 OF 5 |
| DATE 05.12.12 | TITLE SHUT-OFF VALVE ASS'Y | SCALE 1:2 | |

**D3469-5 LOWER PLATE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) SPOT WELD NUT PLATES PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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